

slp July 6

Work Order ID 85739

\*85739\*

Page 1

Item ID: D4017-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/14 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4017	C								
100	Weld per dwg A/R S.S. rod Batch: 4118161	0.00							
*100*	Large Fab								
Large Fab	Memo	0.00							
	1- assemble ribs , weld as per dwg D4017 using DT9610B								
	***inspect before welding mesh***								
	2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary								
	and trim to clear fasteners holes on the ends								
	3- weld hinge (3) and Mounting brackets as per dwg D4017								
	***take lid to locate hinge and bracket***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

(1x)

SH 12.07.05

PC 12.07.05

Pick Kit

12 SP 12-7-9.

# Work Order ID 85739

June-14-12 1:56:16 PM

**\*85739\***

Page 2

Item ID: D4017-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
<b>*125*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

1  $\phi$   $\phi$  P-7.6.

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unauthorized <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material  <input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
---	--	---	---

# Work Order ID 85739

June-14-12 1:56:16 PM

**\*85739\***

Page 3

Item ID: D4017-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Short Basket Base Assembly (350 )

Start Date: 14/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 8:10

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:40

\*\*\*\*\*End coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

IX 12/07/09

1 12-7-11

M121841



# Work Order ID 85739

June-14-12 1:56:16 PM

**\*85739\***

Page 4

Item ID: D4017-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Short Basket Base Assembly (350 )

Start Date: 14/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
<b>*150*</b>									
HandFinish	Memo	0.00				1	φ		BL12-7-10.
Hand Finishing									
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									

*D4032 040*

*85738*

*1 φ BL12-7-10.*

# Work Order ID 85739

**\*85739\***

Page 5

June-14-12 1:56:16 PM

Item ID: D4017-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Short Basket Base Assembly (350 )

Start Date: 14/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

MLJ 12/07/11

MLJ 12/07/11





# Picklist Print

June-14-12 1:56:20 PM

Page 1

Work Order ID: 85739

\*85739\*

Parent Item: D4017-041

\*D4017-041\*

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4017-1 Manufactured No 100 Each 1.0000

- \*D4017-1\*  
Rib

\*\*

B 74318 → 1x *SL 12.07.04*

Location	Loc Qty	Loc Code
WA006	1	
80945	1	

✓ D4018-1 Manufactured No Each 10.0000

- \*D4018-1\*  
Rib

\*\*

B 86016 → 1x *SL 12.07.04*

Location	Loc Qty	Loc Code
WA005	10	
72545	5	
82281	5	

\*\*\*D4018-1 is the same as D4017-3\*\*\*

✓ D4017-5 Manufactured No 100 Each 7.0000

- \*D4017-5\*  
Hinge Rib

\*\*

*SL 12.07.04*

Location	Loc Qty	Loc Code
WA005	7	
76379	7	

1x

# Picklist Print

June-14-12 1:56:20 PM

Page 2

Work Order ID: 85739

\*85739\*

Parent Item: D4017-041

\*D4017-041\*

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100

Each

7.0000

1

1

✓\*D4017-7\*

Rib

\*\*

B85435 SJ 12.07.04

Location

Loc Qty

Loc Code

WA

6

82969

6

WA005

1

69730

1

D4017-9

Manufactured No

100

Each

13.0000

2

2

✓\*D4017-9\*

Rib

\*\*

B85774 → 2x SJ 12.07.04

Location

Loc Qty

Loc Code

WA

7

81445

5

82970

2

WA006

6

70341

2

73531

4

D3916-041

Manufactured No

100

Each

5.0000

2

2

✓\*D3916-041\*

Rib Assembly

\*\*

B85775 → 2x SJ 12.07.04

Location

Loc Qty

Loc Code

WA

2

84383

2

WA006

3

81444

2

85329

1

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  <div style="display: flex; justify-content: space-around;"> <div>Rework <input type="checkbox"/></div> <div>Skid-tube <input type="checkbox"/></div> <div>Crosstube <input type="checkbox"/></div> <div>Prod. Eng. Coord. <input type="checkbox"/></div> <div>Engineering <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Scrap <input type="checkbox"/></div> <div>Machining <input type="checkbox"/></div> <div>Small Fab <input type="checkbox"/></div> <div>Rec/Store/Packaging <input type="checkbox"/></div> <div>Quality <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Use-as-is <input type="checkbox"/></div> <div>Thermoforming <input type="checkbox"/></div> <div>Finishing <input type="checkbox"/></div> <div>Supplier <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Work Order Update <input type="checkbox"/></div> <div>Large Fab <input type="checkbox"/></div> <div>Composite <input type="checkbox"/></div> <div>Other <input type="checkbox"/></div> </div>	
--	---	--

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

**FAULT CATEGORY**

Landing Gear	Hardware	General	Maintenance
<input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other    
		<input type="checkbox"/> Burr <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material

# Picklist Print

June-14-12 1:56:20 PM

Page 3

Work Order ID: 85739

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

**\*85739\***

**\*D4017-041\***

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3916-5

Manufactured No

100

Each

15.0000

1

1

\*\*

B 85777 *SV* 12.07.04

✓ **\*D3916-5\***

Light Rib

Location

Loc Qty

Loc Code

WA

15

77142

1

82933

6

82934

8

D4034-041

Manufactured No

100

Each

3.0000

1

1

\*\*

B 81436 *SV* 12.07.04

✓ **\*D4034-041\***

Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA006

3

81435

3

D4034-043

Manufactured No

100

Each

3.0000

1

1

\*\*

B 82979 *SV* 12.07.04

✓ **\*D4034-043\***

Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

3

81174

2

83756

1

# Picklist Print

June-14-12 1:56:20 PM

Page 4

Work Order ID: 85739

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

\*85739\*

\*D4017-041\*

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

43.0000

2

2

\*\*

B85436 → 2x

12.07.04

✓ \*D2581\*

Mounting Bracket

Location

Loc Qty

Loc Code

WA

5

82506

2

83230

3

WA005

38

70766

2

81253

1

82897

35

D3913-15

Manufactured No

100

Each

8.0000

1

1

\*\*

12.07.04

✓ \*D3913-15\*

Wide Handle Plate

Location

Loc Qty

Loc Code

WA

3

85438

3

WA005

5

82919

5

D4016-1

Manufactured No

100

Each

13.0000

3

3

\*\*

B85437 12.07.04

✓ \*D4016-1\*

Hinge Half, Base

Location

Loc Qty

Loc Code

WA

13

66418

0

84867

13

D4020-3

Manufactured No

100

Each

0.0000

1

1

\*\*

B80944 → 1x 12.07.04

✓ \*D4020-3\*

Mesh (350 Basket Short, Base)

June-14-12 1:56:20 PM

Shop Packet Print

Page 4



# Picklist Print

June-14-12 1:56:20 PM

Page 5

Work Order ID: 85739

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

\*85739\*

\*D4017-041\*

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4020-11

Manufactured No

100

Each

17.0000

2

2

\*\*

*SY 12.07.04*

\*D4020-11\*

End Mesh, Basket

Location

Loc Qty

Loc Code

WA

-1

81442

2

84972

3

85627

6

WA035

18

85357

6

*2x*

D4021-1

Manufactured No

100

Each

9.0000

3

3

\*\*

*B85652 → 3x*

\*D4021-1\*

Handle Plate

Location

Loc Qty

Loc Code

WA

9

69518

0

74316

0

74946

0

85439

9

*W 12.07.04*

D2931

Manufactured No

150

Each

410.0000

2

2

\*\*

*SP 12-7-9*

\*D2931\*

Bumper

Location

Loc Qty

Loc Code

ST504

410

46064

410

*2x*





# Picklist Print

June-14-12 1:56:20 PM

Page 6

Work Order ID: 85739

**\*85739\***

Parent Item: D4017-041

**\*D4017-041\***

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each 10.0000 2

**\*D4021-5\***

Blanking Plate

\*\*

*B85891 SP.*

Location

Loc Qty

Loc Code

ST083

2

84984

2

ST084

8

85065

8

AN3-10A Purchased No

150 Each 139.0000 6

**\*AN3-10A\***

Bolt

\*\*

*m/19778 SP.*

Location

Loc Qty

Loc Code

GA

8

119084

8

ST351

131

117795

2

120873

129

AN960JD8 NAS1149DN832 Purchased No

150 Each 0.0000 2

**\*AN960JD8\***

Washer

\*\*

*m/20422 SP.*

MS20600-AD4W3 Purchased No

150 Each 740.0000 2

**\*MS20600-AD4W3\***

Cherry Rivets

\*\*

*m/22151 SP.*

*12-7-9*

Location

Loc Qty

Loc Code

ST321

607

111636

36

117601

3

118626

310

120308

258

WA018

133

107939

133

June-14-12 1:56:20 PM

Shop Packet Print

Page 6

# Picklist Print

June-14-12 1:56:20 PM

Page 7

Work Order ID: 85739

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

**\*85739\***

**\*D4017-041\***

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,748.000

6

6

**\*MS21042L3\***

\*\*

Nut

Location

Loc Qty

Loc Code

ST300

1748

115835

4

117885

32

119017

816

119075

138

121349

23

121444

735

NAS1149F0332P

Purchased

No

150

Each

1,152.000

12

12

**\*NAS1149F0332P\***

\*\*

WASHER

Location

Loc Qty

Loc Code

ST275

1152

117735

13

119225

10

120986

200

121259

200

121825

126

122063

600

17317

3

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

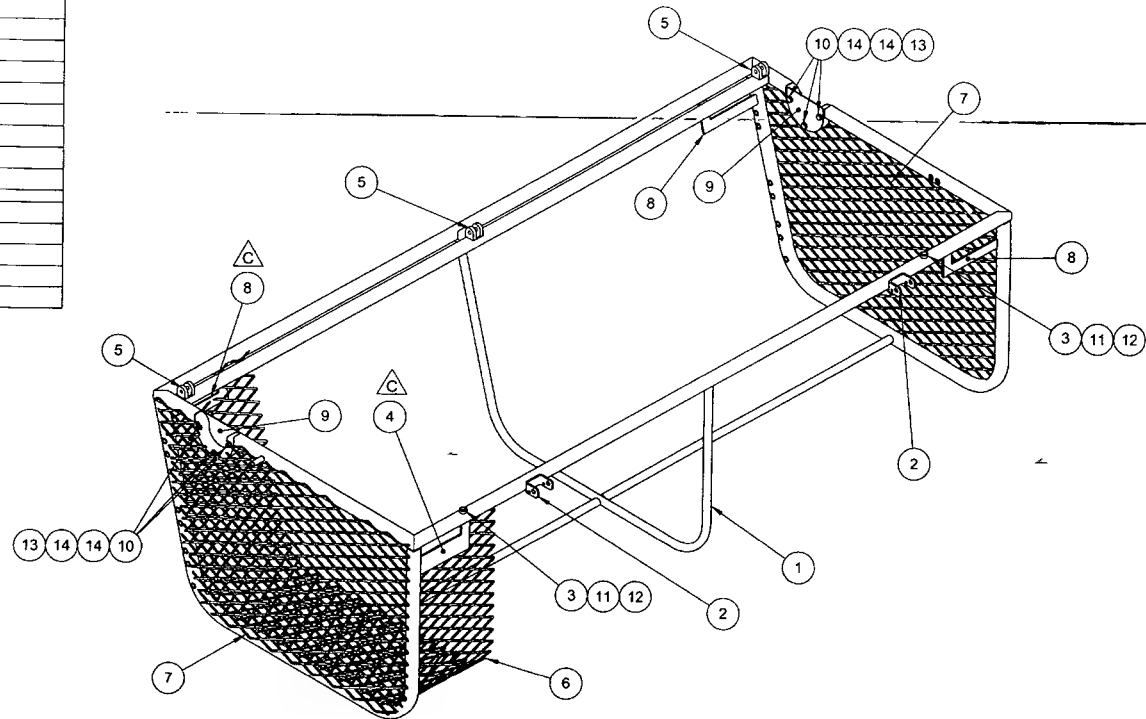
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <input type="checkbox"/> Rework  <input type="checkbox"/> Scrap  <input type="checkbox"/> Use-as-is  <input type="checkbox"/> Work Order Update         </div> <div style="text-align: center;"> <input type="checkbox"/> Skid-tube  <input type="checkbox"/> Machining  <input type="checkbox"/> Thermoforming  <input type="checkbox"/> Large Fab         </div> <div style="text-align: center;"> <input type="checkbox"/> Crosstube  <input type="checkbox"/> Small Fab  <input type="checkbox"/> Finishing  <input type="checkbox"/> Composite         </div> <div style="text-align: center;"> <input type="checkbox"/> Prod. Eng. Coord.  <input type="checkbox"/> Rec/Store/Packaging  <input type="checkbox"/> Supplier  <input type="checkbox"/> Other         </div> <div style="text-align: center;"> <input type="checkbox"/> Engineering  <input type="checkbox"/> Quality         </div> </div>		<b>AGAINST DEPARTMENT/PROCESS</b>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Offset/Setup											
Other											
Process											
Supplier											
Training											
Unauthorized											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596  
**RELEASED**  
10.06.17

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85739 MLJ  
12/06/14

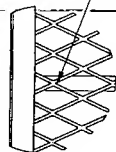
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2), ITEMS RENUMBERED. DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>ALS</u>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>3</u>		
CHECKED	<u>3</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>J.F.S.</u>	<b>D4017</b>	SHEET 1 OF 5
APPROVED	<u>WJ</u>	TITLE	SCALE
DE APPR.	<u>WJ</u>	<b>SHORT BASKET BASE ASSY (350) - NTS</b>	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

05739

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION



**DETAIL C** D5-2

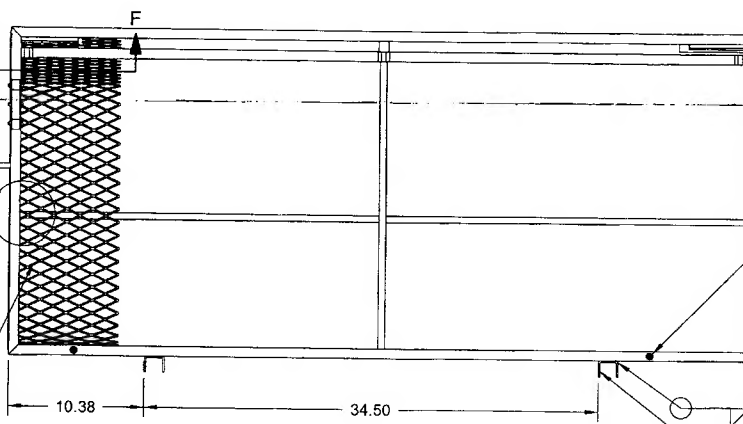
**SECTION F-F**  
TYPICAL FOR ALL  
HANDLE PLATES

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

**SECTION F-F**  
TYPICAL FOR ALL  
HANDLE PLATES

D4021-1  
HANDLE PLATE

D6-2 F  
F  
C8-2  
D4020-3  
MESH



D4017-101  
TUBULAR ASSY

D2931 BUMPER  
AN960JD8 WASHER  
MS20600AD4W3 RIVET  
2 PL [8]

D2581  
MOUNTING BRACKET  
2 PL

2 PL

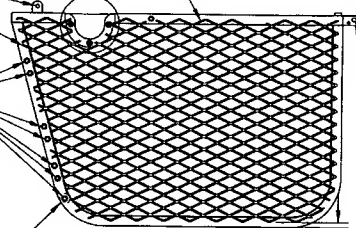
D4020-11  
END MESH

DETAIL D  
6 PL [9]  
A4-3

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

[9]

TRIM MESH TO  
CLEAR BUSHING  
Ø0.75

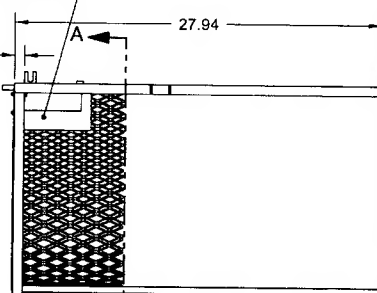


[9] 4 PL

0.38  
TYP

D3913-15  
WIDE HANDLE PLATE

0.75  
2 PL



D4016-1  
HINGE HALF, BASE  
3 PL

D4021-1  
HANDLE PLATE  
2 PL

3 PL

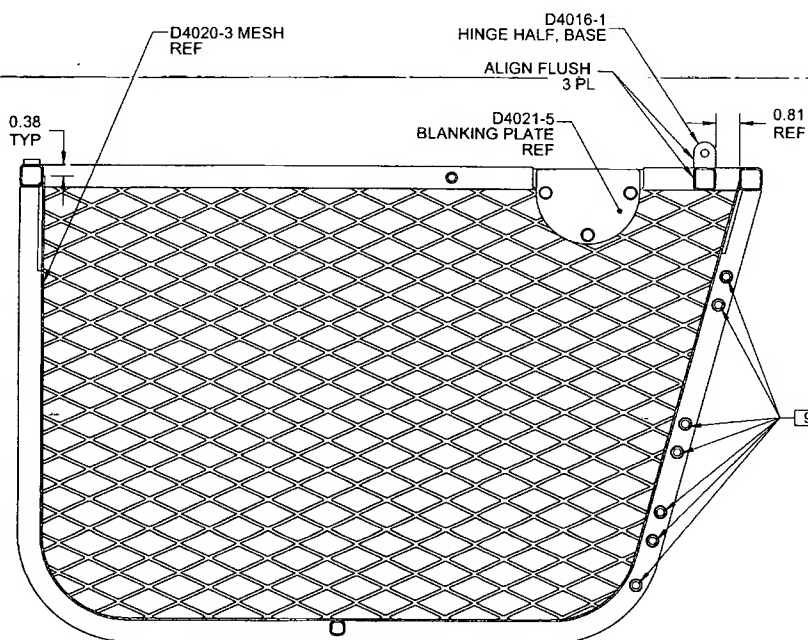
B2-3 B

**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

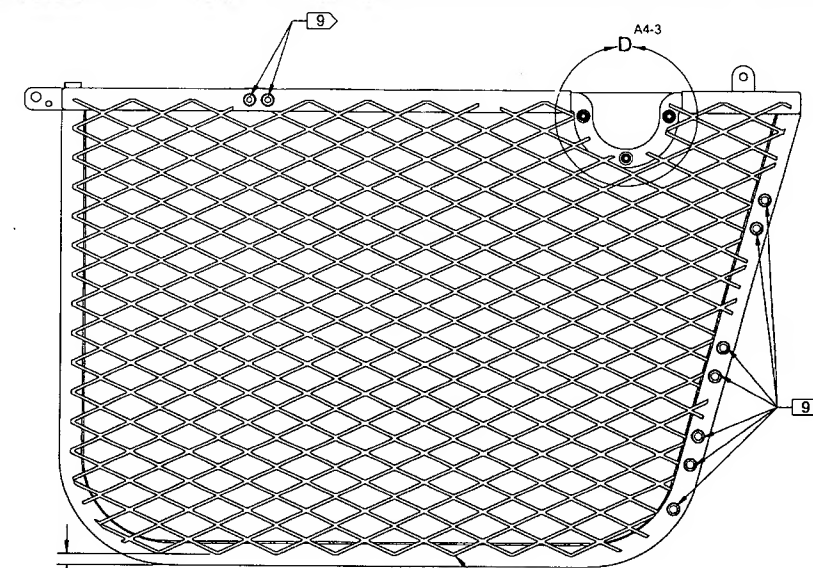
RELEASED  
10.08.17

DESIGN	ALS	<b>DART AEROSPACE LTD</b>
DRAWN	h	HAWKESBURY, ONTARIO, CANADA
CHECKED	JP	DRAWING NO. <b>D4017</b> REV. C
MFG. APPR.	JES	SHEET 2 OF 5
APPROVED	W	TITLE <b>SHORT BASKET BASE ASSY (350)</b> SCALE
DE APPR.	W	NTS.
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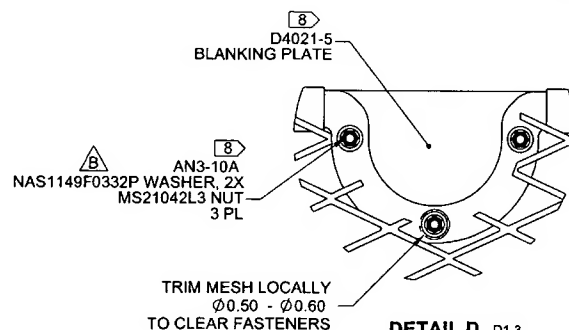
25739



**SECTION A-A** A5-2



**SECTION B-B** A2-2

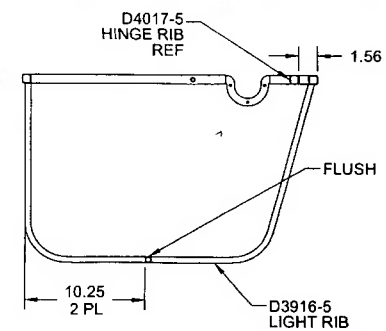
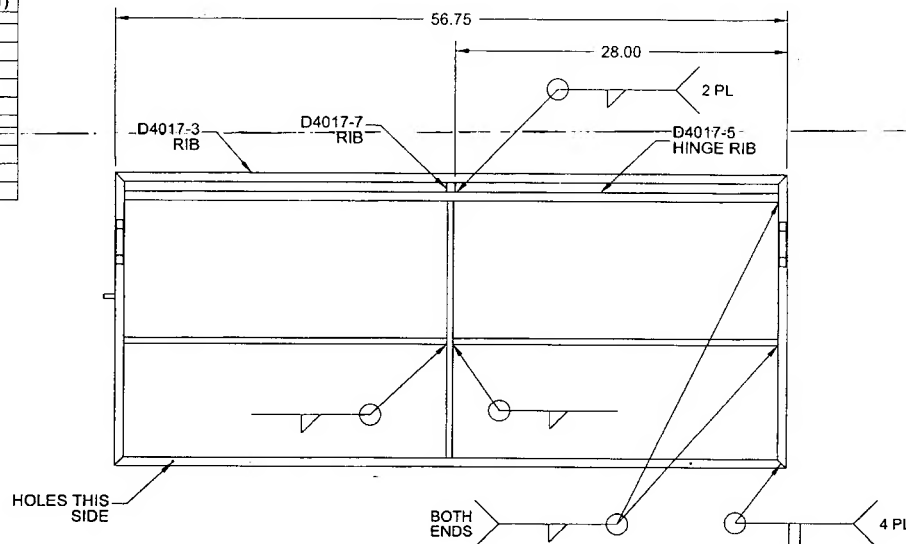


**DETAIL D** D1-3 B8-2

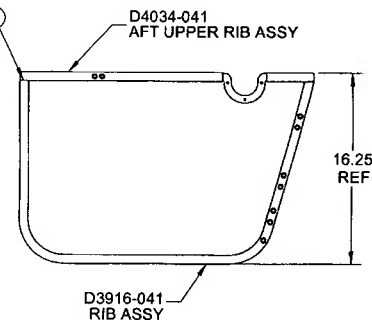
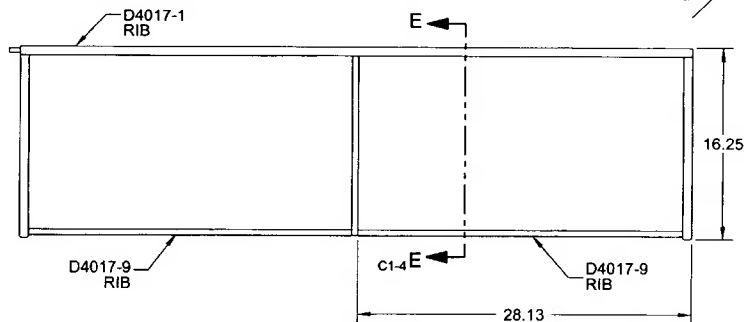
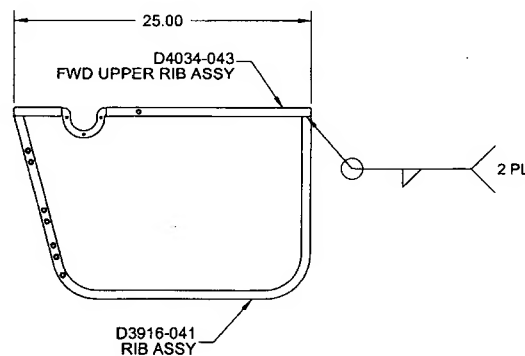
RELEASED  
10-08-12-4

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4017	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT-BASKET-BASE ASSY (350) - NTS	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION E-E A4-4



8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 15.26 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4017-101
  - 9) WELD PER DART QSI 004

DESIGN	AKS	DART AEROSPACE LTD	REV. C
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4017	SHEET 4 OF 5
MFG. APPR.	SYS. D.L.M.	TITLE	SCALE
APPROVED		SHORT BASKET BASE ASSY (350) NTS	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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